

# Work Order ID 56093

February 10, 2010 12:13:15 PM



Page 1

Item ID: D3443-7

Revision ID:

Item Name: Tubing

Start Date: 2/10/10 Start Qty: 10.00

Required Date: 2/26/10 Req'd Qty: 10.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:



Approvals:

Process Plan:

*Handwritten signature*

Date: 10-2-10

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3443

Rev C

100



NC BRAKE

0.00

Brake NC

Memo

0.00

Brake NC

1- Form as per Dwg D3443 using DT8117 2- Deburr per dwg D3443

*Handwritten:* 10/03/09 (10X) SAD 10-02-2

110



Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

GRIND RAD PER DWG

*Handwritten:* 10/03/09 (10X)

120



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

*Handwritten:* 10/03/09

*Handwritten:* (10X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries

**Work Order ID 56093**

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Page 2

Item ID: D3443-7

Accept



Setup Start



Revision ID:

Item Name: Tubing

Stop



Start Date: 2/10/10

Start Qty: 10.00



Cust Item ID:

Required Date: 2/26/10

Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



Mill Conv

CONVENTIONAL MILLING MACHINE

0.00

*\* Attention: tube size cut long \**

Memo

0.00

Conventional Milling Machine

1- Mill end to length and drill hole as per dwg D3443-2-Deburr as per dwg D3443

*SK 10/03/11*

140



QC

QC2- Inspect parts off machine FAI/FAIB

0.00

*SK 10/03/11*

Memo

0.00

Quality Control

150



QC

QC8- Inspect parts - second check

0.00

*S.P. 10/03/11*

Memo

0.00

Quality Control

*6**0*



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Page 3

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Revision ID:

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Start Date: 2/10/10

Start Qty: 10.00

Required Date: 2/26/10

Req'd Qty: 10.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

Identify as per dwg & Stock Location *Caul*

0.00



Packaging

Memo

0.00

Packaging

10-3-12

100

*SP*

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/10 *JA**me*  
10-3-12

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**NOTE:** Date & initial all entries

# Picklist Print

February 10, 2010 12:13:19 PM

Page 1

Work Order ID: 56093

Parent Item: D3443-7

Parent Item Name: Tubing


Comments: A ☐ 05.11.14 ☐ New issue ☐ EC ☐

Start Date: 2/10/10

Required Date: 2/26/10

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304TR0.750W.120  304 ss round tube .750 x .120w		Purchased	No			100	f	9.6948	7.8947			



SAD 10-02-23

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

MAT

9.6948

111096

9.6948

M 114 077

4  
6



W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries





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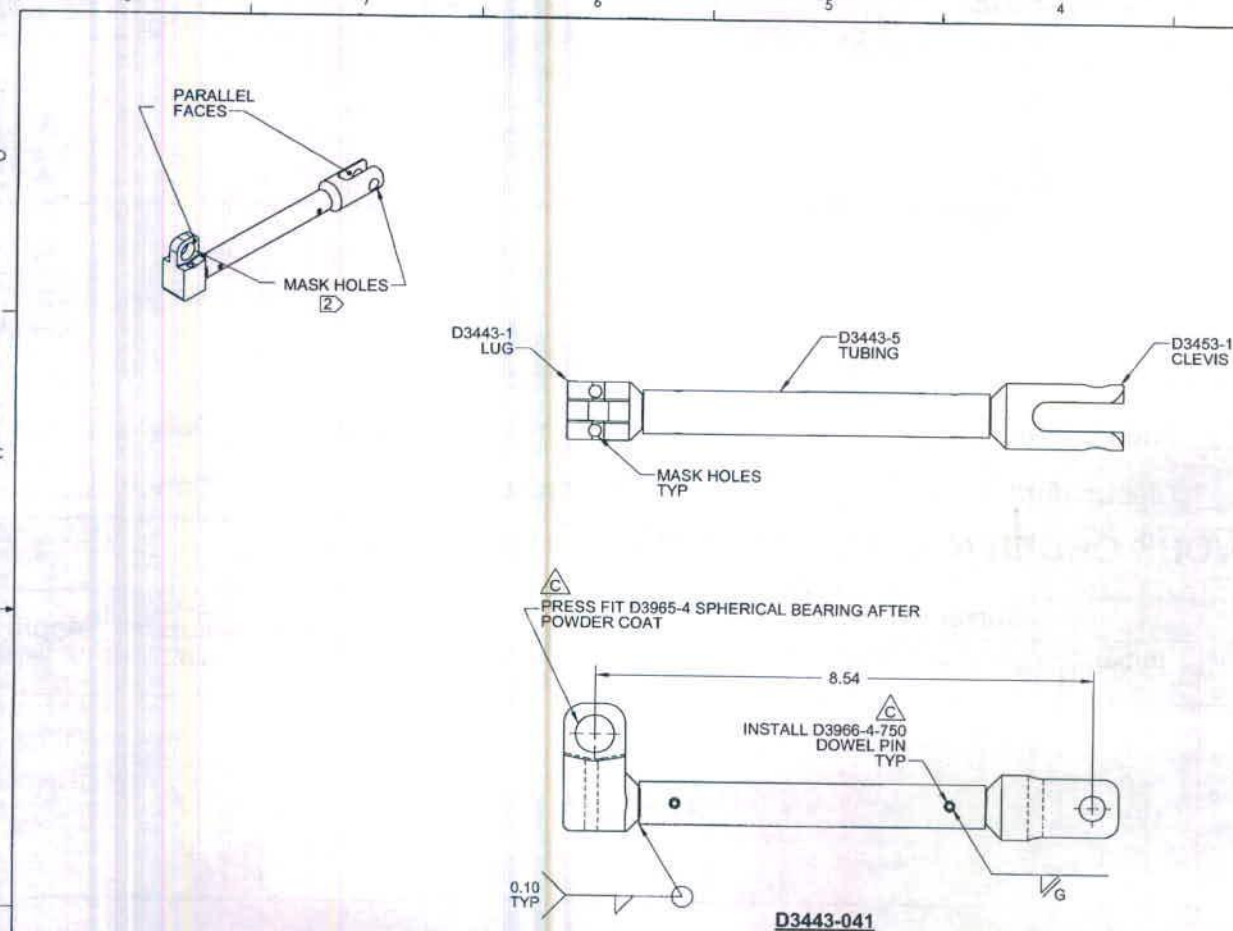
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries





# NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3  
NO POWDER COAT IN HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.33 lbs
- 8) WELD PER DART QSI 004

ITEM	QTY	P/N	DESCRIPTION
1	X	D3443-041	STRUT WELDMENT ASSEMBLY
2	1	D3443-1	LUG
3	1	D3443-5	TUBING
4	1	D3453-1	CLEVIS
5	1	D3965-4	BEARING, SPHERICAL
6	2	D3966-4-750	PIN, DOWEL

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 34093  
BJ 10-210

RELEASED  
9/16/25 MP

C	DRAWING UPDATED TO CURRENT STANDARDS. REVISED NOTE #2 (ZN AB-1, AB-2) 0.020 WAS 0.720 & 1.43 WAS 1.53 (ZN C2-3); 0.551 WAS 0.451 (ZN C1-3); R0 219 WAS R0.050 (ZN C4-3); D3965-4 WAS SPAENAU P/N (ZN C6-1, B5-2); D3966-4-750 WAS MCMASTER-CARR P/N (ZN B5-1); REF PAR 09-018	RF	09.06.25
B	ADDED -9 PIN; REMOVED BALL PLUNGER; REVISE TOLERANCE: & Ø 0.125 WAS #30	RF	05.12.05
A	NEW ISSUE	RF	05.09.02
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.06.25		

DART AEROSPACE LTD  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.  
D3443  
REV. C  
SHEET 1 OF 4  
SCALE  
STRUT WELDMENT ASSEMBLY NTS

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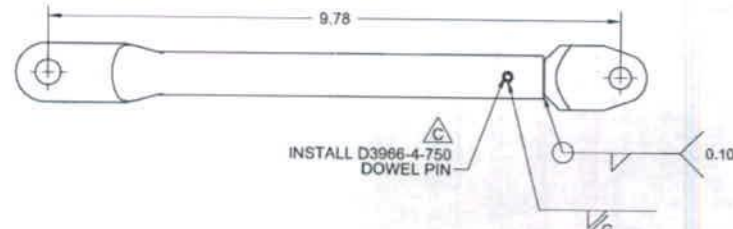
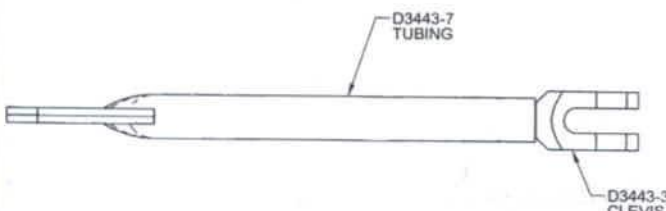
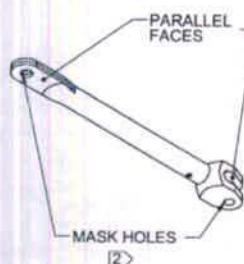
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**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1



D3443-043

ITEM	QTY	P/N	DESCRIPTION
1	X	D3443-043	STRUT WELDMENT ASSEMBLY
2	1	D3443-3	CLEVIS
3	1	D3443-7	TUBING
4	1	D3966-4-750	PIN

WLO 56093

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3  
NO POWDER COAT IN HOLES
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: 0.97 lbs
  - 8) WELD PER DART QSI 004

RELEASED  
09/06/25/14

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	UP	DRAWING NO.	REV. C
MFG. APPR.		D3443	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		STRUT WELDMENT ASSEMBLY	NTS
DATE	09.06.25	COPYRIGHT © 2005 BY DART AEROSPACE LTD	

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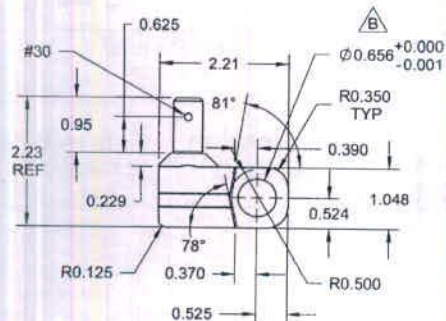
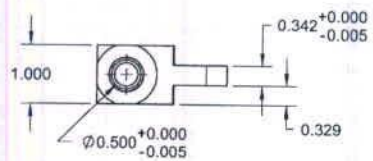
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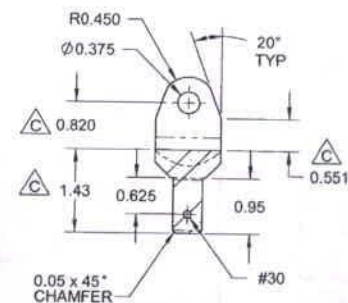
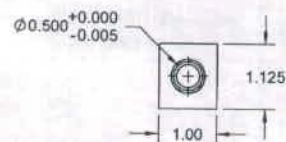
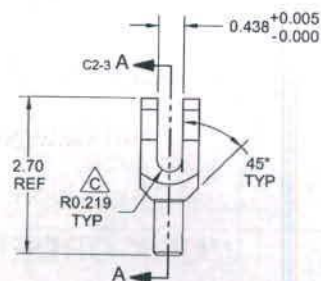
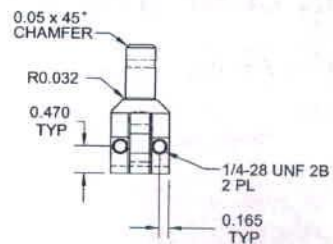
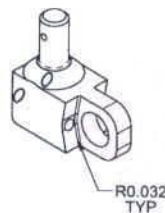
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**D3443-1 LUG**



**SECTION A-A C4-3**

**D3443-3 CLEVIS**

**NOTES:**

- 1) MATERIAL: D3443-1 = 17-4 SS PER AMS 5604/5643 (REF DART SPEC M17-4B)  
D3443-3 = AISI 304 SS ROUND BAR (REF. DART SPEC M304R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3443-1 = 0.50 lbs  
D3443-3 = 0.35 lbs

*W/O 56093*

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*09/06/25/14*

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MFG. APPR.	<i>[Signature]</i>	D3443	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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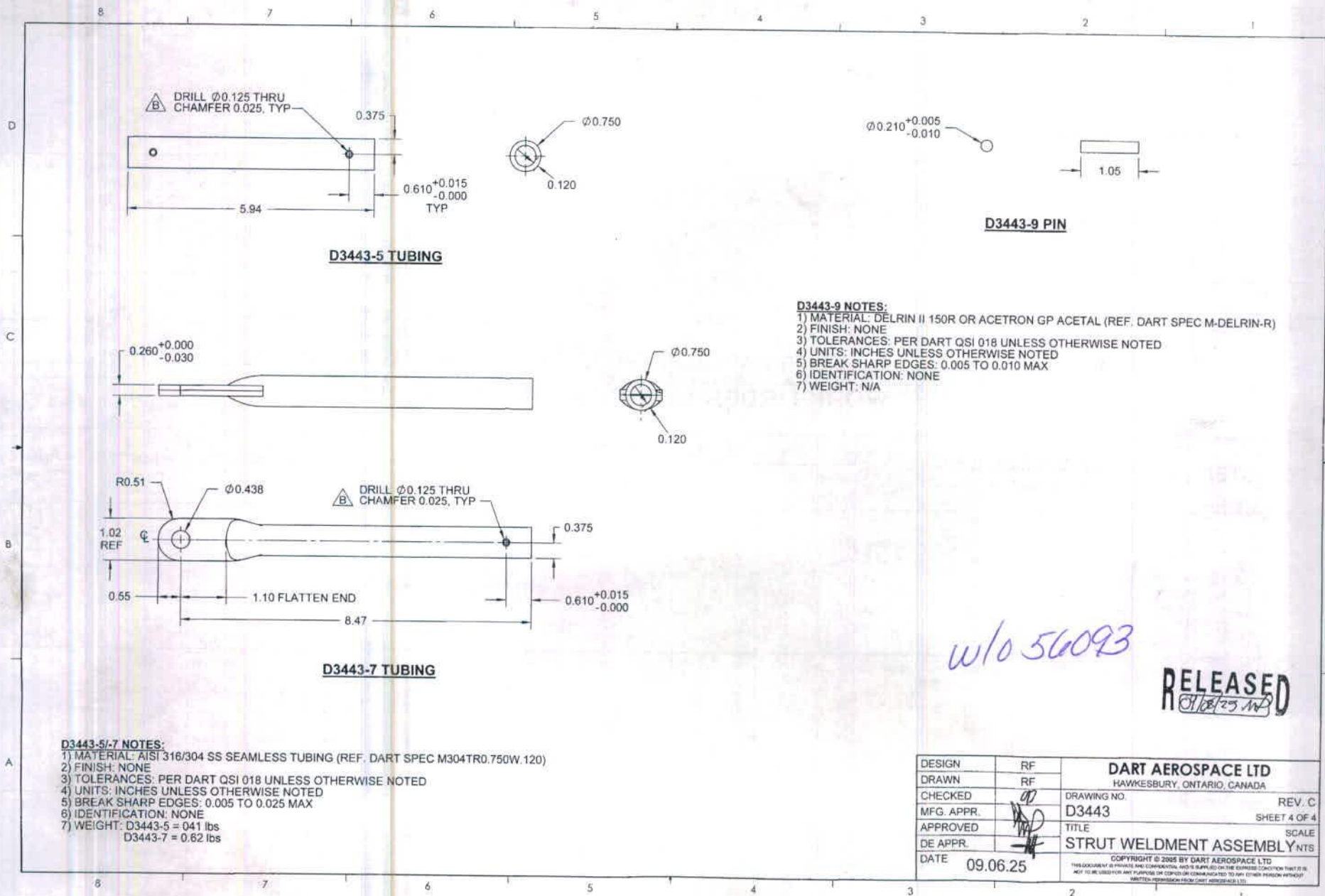
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W/O 56093

RELEASED  
01/02/25 W/O



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